



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

001146



K10003
Job Sheet 171258

Part No: K10003

Job Qty: 4 ea

Part Name: Saddles



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP: 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF IPP : J 06-07-25 As per DSI 9344
JLM IPP : K 06.11.17 Per K10003 Rev C KJ IPP : L 07.01.12 Document Record for copying bluefile rmv KJ
IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified: IPP N 09.01.27 DSI 9418 rev B EC verified:DD
IPP Rev:O 11.03.11 per dsi9536 DD ver:EC IPP REV:P 12.01.23 AS PER ECN11-684 VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/9/18	2/9/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 09 2018
110	Packaging	4 pcs	2/9/18	2/9/18	0.00	0.00	Packaging1-5		MAR 09 2018
120	QC	4 pcs	2/9/18	2/9/18	0.00	0.00	QC4		
125	DC	4 pcs	2/9/18	2/9/18	0.00	0.00	DC		
130	Packaging	4 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-2		
140	QC21-FG	4 Ea	2/9/18	2/9/18	0.00	0.00	QC21		MAR 12 2018

Part Op Descriptions: 125 - Create White labels only per PPP K10003 CHG 0010

No CHG#

DAS
35
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-51A	Bolt	32 Ea (8 ea)	90-Start up Operation	M137951-3
AN4-6A	Bolt	64 Ea (16 ea)	90-Start up Operation	5019399 62x
AN4C46A	Bolt	16 Ea (4 ea)	90-Start up Operation	5006303x6 FM1373 16 x 10
AN6-12A	Bolt	32 Ea (8 ea)	90-Start up Operation	5024842
D2570	Bushing	96 Ea (24 ea)	90-Start up Operation	5042494
D2571	Saddle, Fwd, Out	4 Ea (1 ea)	90-Start up Operation	5036736
D2572	Saddle, Fwd, In	4 Ea (1 ea)	90-Start up Operation	5037858
D2573	Saddle, Aft, Out	4 Ea (1 ea)	90-Start up Operation	5038662
D2574	Saddle, Aft, In	4 Ea (1 ea)	90-Start up Operation	5038658
D2747	Set Screw	16 Ea (4 ea)	90-Start up Operation	F164972
D2876	Saddle Spacer	8 Ea (2 ea)	90-Start up Operation	F165495x3 16x389x5
D2877	Saddle Spacer	8 Ea (2 ea)	90-Start up Operation	5042020
D3405-041	Ground Handling Lug	4 Ea (1 ea)	90-Start up Operation	5020816
D3405-043	Ground Handling Lug	4 Ea (1 ea)	90-Start up Operation	5026298x
D3407-041	Tow Ring	4 Ea (1 ea)	90-Start up Operation	5043180
D3417-5	Washer	8 Ea (2 ea)	90-Start up Operation	5017165
D3456-1	Washer	4 Ea (1 ea)	90-Start up Operation	5012112
D3533-1	Set Screw	8 Ea (2 ea)	90-Start up Operation	F163999
MS21042L4	Nut	96 Ea (24 ea)	90-Start up Operation	5016351
MS21043-4	Nut	20 Ea (5 ea)	90-Start up Operation	5027733
NAS1149D0463J	Washer	128 Ea (32 ea)	90-Start up Operation	5024481

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																											
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Dart Aerospace Ltd. 1270 Aberdeen Street Hewkebury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S049635 Part: K10003 Job No: 171258 Serial No/Batch: S049635 Revision: Inspector: Date: 03/09/18		Completed By																																																	
		Lead hand / Supervisor Approval Verification																																																	
		QC / QA Coordinator Approval																																																	
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OTHER :																																																			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-51A	32	140	0
	AN4-6A	64	511	0
	AN4C46A	16	289	0
	AN6-12A	32	185	0
	D2570	96	420	0
	D2571	4	13	0
	D2572	4	11	0
	D2573	4	11	0
	D2574	4	7	0
	D2747	16	200	0
	D2876	8	43	0
	D2877	8	32	0
	D3405-041	4	31	0
	D3405-043	4	21	0
	D3407-041	4	17	0
	D3417-5	8	50	0
	D3456-1	4	120	0
	D3533-1	8	68	0
	MS21042L4	96	2,470	0
	MS21043-4	20	988	0
	NAS1149D0463J	128	4,080	0
	NAS1149D0663J	32	1,111	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001146	S045054	AN4-51A	Bolt	FM137951-3	Start Up Stores/Pkg-1	32
001146	S045053	AN4-6A	Bolt	S019399	Start Up Stores/Pkg-1	64
001146	FM137316	AN4C46A	Bolt		Start Up Stores/Pkg-1	10
001146	S045052	AN4C46A	Bolt	S006303	Start Up Stores/Pkg-1	6
001146	S045051	AN6-12A	Bolt	S024842	Start Up Stores/Pkg-1	32
001146	S045050	D2570	Bushing	S042494	Start Up Stores/Pkg-1	96
001146	S045049	D2571	Saddle, Fwd, Out	s036736	Start Up Stores/Pkg-1	4
001146	S037858	D2572	Saddle, Fwd, In	F164405-1	Start Up Stores/Pkg-1	4
001146	S045048	D2573	Saddle, Aft, Out	s038662	Start Up Stores/Pkg-1	4
001146	S045047	D2574	Saddle, Aft, In	s038658	Start Up Stores/Pkg-1	4
001146	S045046	D2747	Set Screw	F164972	Start Up Stores/Pkg-1	16
001146	F165495	D2876	Saddle Spacer		Start Up Stores/Pkg-1	1
001146	S045045	D2876	Saddle Spacer	f164389	Start Up Stores/Pkg-1	7
001146	S045044	D2877	Saddle Spacer	S042020	Start Up Stores/Pkg-1	8
001146	S045043	D3405-041	Ground Handling Lug	s026304	Start Up Stores/Pkg-1	4
001146	S026298	D3405-043	Ground Handling Lug	S038860	Start Up Stores/Pkg-1	1
001146	S049631	D3405-043	Ground Handling Lug	S048816	Start Up Stores/Pkg-1	3
001146	S045041	D3417-5	Washer	S017165	ST034	8
001146	S045040	D3456-1	Washer	S012112	Start Up Stores/Pkg-1	4
001146	S045039	D3533-1	Set Screw	f163999	Start Up Stores/Pkg-1	8
001146	S045037	MS21042L4	Nut	S016351	ST303	96
001146	S045038	MS21043-4	Nut	S027733	ST302	20
001146	S045007	NAS1149D0463J	Washer	S027736	ST263	128
001146	S045003	NAS1149D0663J	Washer	S024481	ST263	32

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/9/18 11:17 AM dart.quirion.sonia

5.0 PARTS LIST

5.1 Skidtube Installations with Standard Wearshoes

Item	634 -011	634 -015	634 -041	634 -045	634 -047	641 -011	Part Number	Description
	X						D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X					D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
1			X				D205-634-041	SKIDTUBE
		1		X			D205-634-045	SKIDTUBE
					X		D205-634-047	WEARSHOE KIT
1	1	1				X	D205-641-011	GROUND HANDLING KIT
1			1				D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1			D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16			D2594-1	* PLUG
2B			16	16			D2594-3	* O-RING
3			1	1			D2855	* AFT CAP
4			2	2			AN3-5A	* BOLT
5			2	2			NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
7A			1	1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
8A			1	1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
9A			1	1	1		D3564-13	* WEARSHOE
10			50	50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50			ALS4-1032-130	* INSERT
13			2	2			ALS4-1032-225	* INSERT
20	1	1					D2571	SADDLE, FWD OUTSIDE
21	1	1					D2572	SADDLE, FWD INSIDE
22	1	1					D2573	SADDLE, AFT OUTSIDE
23	1	1					D2574	SADDLE, AFT INSIDE
24	8	8					AN4-51A	BOLT
25	16	16					D2570	BUSHINGS
26	8	8					MS21042L4	NUT (OR MS21042-4)
27	8	8					AN6-12A	BOLT
28	8	8					NAS1149D0668J	WASHER (AN960JD616)
29	16	16					AN4-6A	BOLT
30	32	32					NAS1149D0463J	WASHER (AN960JD416)
31	16	16					MS21042L4	NUT (OR MS21042-4)
32	4	4					D2747	SET SCREW
33	2	2					D3533-1	SET SCREW
40	1	1					D3407-041	TOW RING (REPLACES D2968-041)
41	1	1					D3456-1	WASHER
43	1	1					MS21043-4	NUT
44	2	2					D3417-5	WASHER
50						1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51						1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52						4	AN4C46A	BOLT
53						8	D2570	BUSHING
54						4	MS21043-4	NUT (OR MS21042-4)
60	2	2					D2876	SADDLE SPACER
61	2	2					D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE